

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004146**Date Inspected:** 21-Sep-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** CK Chan / Jeff Chen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this date, Caltrans Office of Structure Materials (OSM) Quality Assurance Inspector (QA) Raymond Lara was present at jobsite in Zhenhua Port Machinery Company facility on Changxing island, China for the purpose of observing and monitoring the fabrication of the tower.

**Heavy Shop Bay 1**

The Quality Assurance Inspector observed ZPMC utilizing a milling machine in the beveling process on longitudinal stiffener and skin plates.

The Quality Assurance Inspector observed ZPMC personnel in process of repairing by grinding on completed cover passes on longitudinal stiffener to skin plate B and E South Tower Assemblies.

**Heavy Shop Bay 2**

The Quality Assurance Inspector observed ZPMC utilizing a milling machine in the beveling process on longitudinal stiffener and skin plates.

The Quality Assurance Inspector observed ZPMC personnel in process of performing thermal cutting on floor beam plate number FD016-28.

The Quality Assurance Inspector observed ZPMC personnel in process of repairing by grinding on completed

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cover passes on longitudinal stiffener to skin plate C and D East Tower Assemblies.

### Bay 3

The Quality Assurance Inspector observed ZPMC grinding and performing flux core arc welding (FCAW) on visual weld repairs on Orthotropic Box Girders (OBG) DP-591-001 and DP-164-001.

The Quality Assurance Inspector performed a random final visual observation on Orthotropic Box Girder (OBG) DP-164-001. The items observed by the Quality Assurance Inspector appear to meet contract requirements.



### Summary of Conversations:

No relevant conversations on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Joshua Ishibashi, (707) 649-5453, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Lara, Raymond	Quality Assurance Inspector
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<b>Reviewed By:</b>	Lanz, Joe	QA Reviewer
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